

303 2.00

Work Order ID 82899

82899

Page 1

Tuesday, April 10, 2012 2:33:04 PM

Item ID: D3912-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Eyebolt

Start Date: 4/10/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: *P*Date: *12-04-12* Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3912

B

-0.00

100

100

Doosan

Doosan Lathe

Memo

0.00

TURN AS PER FOLIO FA871AND DWG

Prog Rev: *B*Dwg Rev: *2*

Deburr as required

*SL 12/4/14**13 4*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

*SL 12/4/14**13 4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82899

82899

Page 2

Tuesday, April 10, 2012 2:33:04 PM

Item ID: D3912-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt
 Start Date: 4/10/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: ST70	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

B.A 12/04/18

13

0

Bx

12-04-18

12/4/19

12-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 10, 2012 2:33:08 PM

Page 1

Work Order ID: 82899

82899

Parent Item: D3912-1

D3912-1

Parent Item Name: Eyebolt

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased	No			100	f	5.9310	0.25	3.157895			
M303R2 000									**				
303 ROUND BAR 2"													

Location

Loc Qty

Loc Code

MAT029

5.931

116656

1.427

116700

4.504

52 12/4/14

3.15 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82899
Description: Eyebolt		Part Number:	D3912-1
Inspection Dwg: D3912 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.125	/		SA-P	✓
Ø0.700	+/-0.010	.699	/			
Ø0.500	+/-0.010	.495	/			
0.90	+/-0.030	.905	/			
0.13 x 45°	+/-0.030 x 0.5°	.13 x 45°	/			
0.22	+/-0.030	.212	/			
0.75	+/-0.030	.750	/			
0.970	+/-0.010	.962	/			
1.72	+/-0.030	1.701	/			
1.20	+/-0.030	1.196	/			
0.625	+/-0.010	.625	/			
2.23	+/-0.030	2.227	/			
R0.13	+/-0.030	R.13	/		R.G.	
R0.015	+/-0.010	R.015	/		R.G.	
0.625	+/-0.010	.625	/			
Ø0.650	+/-0.010	Ø.650	/			
1.100	+/-0.010	1.098	/			
0.44	+/-0.030	.44	/			
R0.13	+/-0.030	R.125	/		R.G.	
1.00	+/-0.030	1.00	/			
0.25	+/-0.030	.270	/			
0.88	+/-0.030	.88	/			
0.11	+/-0.030	.11	/			
Ø0.719	+0.010/-0.000	.725	/			

Measured by:	SA	Audited by:	S.A.	Preliminary Approval:	
Date:	12/4/14	Date:	12/04/18	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
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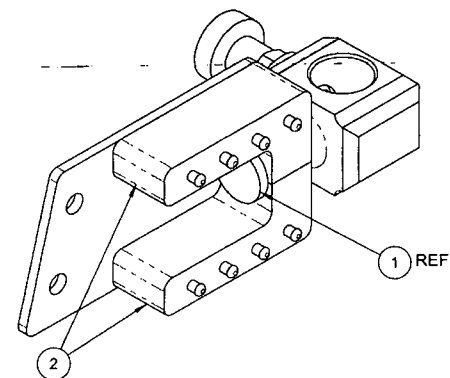
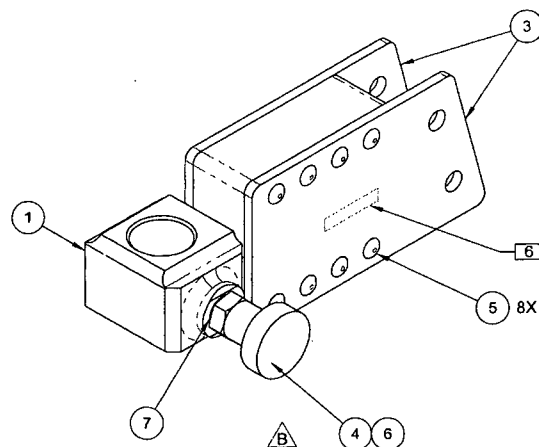
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
2010-07-16

D3912-041 EYEBOLT RECEIVER ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -041: 1.58 lbs

REV.	DESCRIPTION	BY	DATE
B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
DESIGN	1.5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1.1	DRAWING NO. REV. B	
CHECKED	1.1	D3912 SHEET 1 OF 3	
MFG. APPR.	1.1	TITLE SCALE	
APPROVED	1.1	EYEBOLT RECEIVER ASSY NTS	
DE APPR.	1.1	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.06.28	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

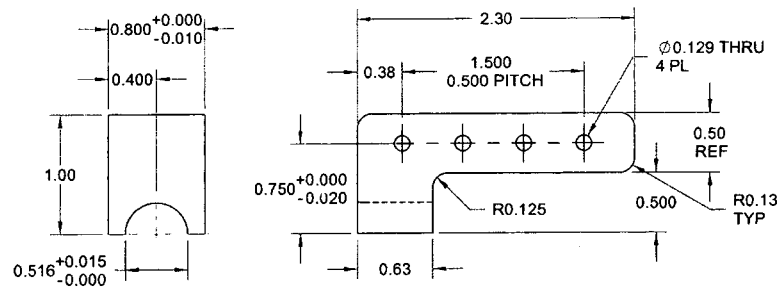
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

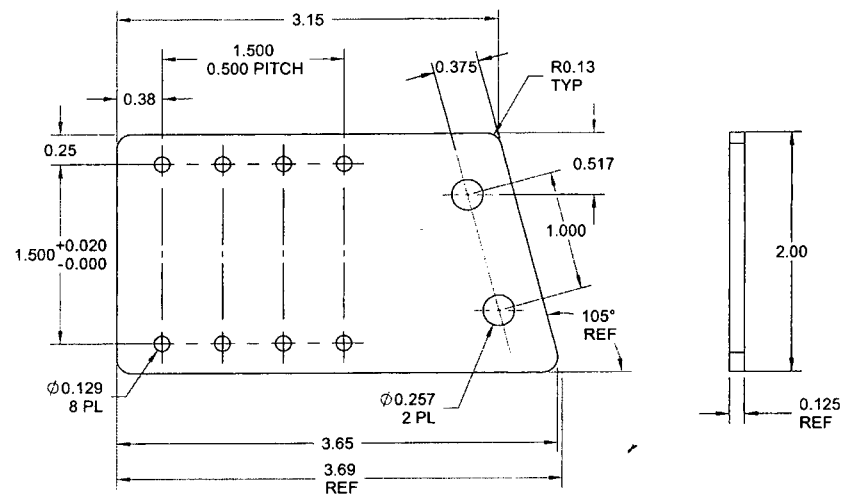
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16

DESIGN	1.15	DART AEROSPACE LTD	
DRAWN	1/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/1	DRAWING NO.	REV. B
MFG. APPR.	1/1	D3912	SHEET 3 OF 3
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	EYEBOLT RECEIVER ASSY	NTS
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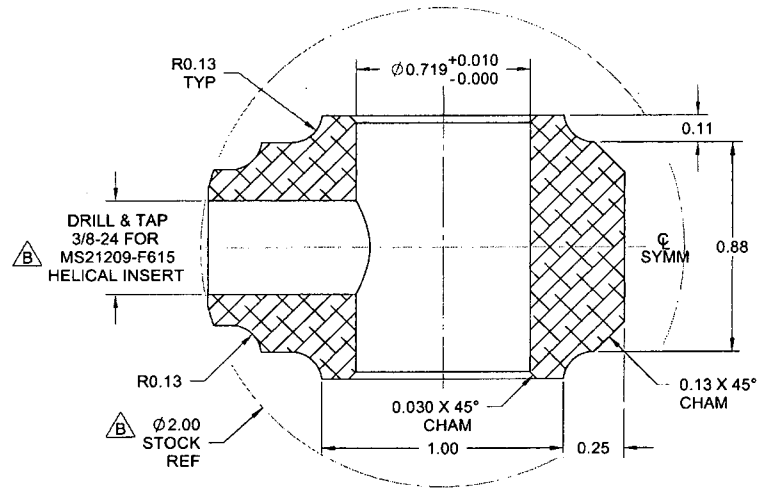
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NOTE: Date & initial all entries



RELEASED
2010-07-16

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT: 0.45 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3912	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	EYEBOLT RECEIVER ASSY	NTS
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